

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007076**Date Inspected:** 09-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2130**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Makhmud Ashadi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

On this date, 6/09/09, Caltrans OSM Quality Assurance Inspector (QAI) Mike Brcic was present during the times noted above for observations relative to the work being performed on cast sections and their associated built up plate sections in the Fabrication shop #4 and Foundry at Japan Steel Works (JSW), Muroran, Hokkaido, Japan.

WEST DEVIATION SADDLES

W2E1 - QA Inspector noted Saddle Section having been welded in Fabrication shop #4. Per JSW representative, Mr. Hideaki Kon, the repair of joint E1Y-5U took place earlier today (photo attached).

W2E2 - Area on Saddle between end plate 2-4 and rib 2-7 has been ground to a more suitable surface for Wet Magnetic Particle Testing method to fulfill requirement of ABF-RFI-1703.

W2W2 - Buttering (surfacing cast material) of lifting lugs on each end of saddle casting has 3 of 4 locations complete, last location is now under preheat in Fabrication Shop #4. The built up plate portion which is located adjacent its mating Cast, has returned from having its "mill to bear" surface prepared.

W2W3 - Saddle Casting is idle in Foundry. CWI QC Inspectors Mr. Chung Fu Kuan and 2nd Shift QC CWI Makhmud Ashadi randomly verified parameters described in procedure SJ-3011-2 as welders M.Kato 08-5018, T. Watanabe 08-5169 and M.Inoue 92-5683 welded joints W3Y-9L, W3Y-10L and W3Y-17L-2 respectively, with FCAW process and TM55 consumable weld wire (Welder S.Watanabe was added to weld on joint W3Y-9V as 2nd shift CWI began his rounds).

TOWER SADDLES

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T1-2 - Tower saddle structure is now being welded to its base plate, welders currently active were T.Isobe 08-5176 and J.Yaegashi 07-2941, joints assigned were 8S-2L, 8S-3L (respectively). QC CWI Mr. Chung Fu Kuan randomly assured compliance to procedure SJ-3012-3, FCAW process utilizing consumable wire TM55 in the 1G position.

T1-3 - Saddle structure has returned from getting a blasting of welds joining the built up section to the cast section, Nikko Inspection Service technician Mr. R.Kumagai #132 is performing a post ISR Magnetic Particle inspection, method is dry powder, AC magnetization induced with a contour probe.

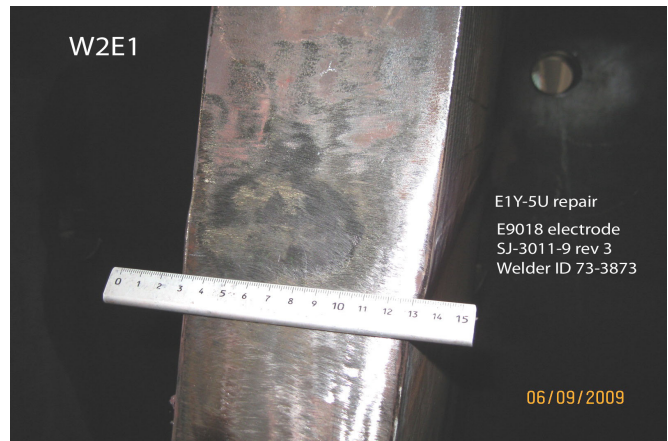
EAST DEVIATION SADDLES

E2E1 - Saddle casting is undergoing defect removal by one man to side opposite the ID in the Foundry shop. In Fabrication Shop #4, Splay plate cover, pc mk 21-1 base to 21-4 was being welded by K.Kobayashi 08-5023 per procedure SJ-3177-2, FCAW, TM55 wire, in a 1G position. This CJP joint is one with backing bar and a 10mm root opening, completed by end of this QA Inspectors shift.

E2W1 - Saddle casting has been moved to a weld pit, placed under fire proof blankets and is currently being welded by S.Morohashi 91-2255 H.Onodera 93-2272. Parameters of procedure SJ-3026-4 is being randomly monitored by Weld Engineer Mr. T.Imai in Foundry. In Fabrication Shop #4, JSW fitter is placing C channels, pc mks 21-2 and 21-3, in place for fit up on Bearing plate 21-1.

West Jacking Saddle has one JSW personnel actively shaping by way of Carbon Arc, in Foundry, approximately 45% complete this side.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.



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Summary of Conversations:

No significant conversations to report on this day.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Brcic,Michael	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
